

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003917**Date Inspected:** 18-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lin Yan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Tower Skin Plate Tower	NA	NA	Heat Straightening

Heavy Shop 1: The Caltrans QA inspector observed ZPMC performing heat straightening operations at skin plate D, longitudinal stiffener plates. The ZPMC heat straightening procedure is identified as HSR1 (T) 4242. Caltrans QA inspector observed ZPMC Quality Control (QC) inspector monitoring the heat straightening of the longitudinal stiffeners using a calibrated infra-red temperature indicating device to monitor the heat.

2	Floor Beam OBG	NA	NA	QAMT
---	-------------------	----	----	------

Bay 7: Caltrans QA inspector performed magnetic particle testing (MT) per ZPMC notification of witness inspection, document number 001052, dated September 18, 2008. The subassemblies were identified as floor beam FB078-001 and FB001-001. Caltrans QA inspector performed ten percent MT weld inspection. The welds appeared to be in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated September 18, 2008 for additional information.

Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

As identified with in the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 137-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
